

Title (en)

CIRCUIT FOR CONTROLLING THE HOLDING FORCE OF A BLANK HOLDER IN A DEEP DRAWING PRESS

Publication

EP 0330718 B1 19920805 (DE)

Application

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Priority

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Abstract (en)

[origin: EP0330718A1] A circuit is described for controlling the holding force of a hydraulic blank holder in a deep drawing press in which a blank to be drawn is clamped between a movable top part and a movable bottom part of the blank holder and is moved by the latter against a drawing punch, and the bottom part of the blank holder is supported by at least one hydraulic displacement cylinder in whose outlet line a control valve activated by the circuit is arranged. The circuit has a pressure transducer which receives the actual hydraulic pressure prevailing in the displacement cylinder and transmits a corresponding actual electric signal, and a controller to which a signal derived from the difference between a desired electric signal corresponding to a desired pressure and the actual signal is fed and which transmits a signal influencing the control valve. The circuit comprises a limiter to which the differential signal is fed and whose output is connected to the input of the integrator of the controller, and furthermore a differentiator to which the actual signal is fed and whose output signal is fed to the integrator, and also a comparator which activates a circuit device and renders the differentiator effective only when the said differential signal drops below a predetermined threshold value. <IMAGE>

IPC 1-7

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IPC 8 full level

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CPC (source: EP)

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